

shp Nov. 12

Work Order ID 62532



Page 1

Monday, October 04, 2010 10:14:56 AM

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 10/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date: 10-10-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Eurocopter

Siolulos

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod *M108436*

3-Grind End Plate flush *M114879*

10-10-26

10 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 11/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 ~~0~~ 3E 10/10/26

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/10/27

HO
LH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7 10/10/27

X10 LH

W/O:		WORK ORDER CHANGES					
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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

10.10.28

0.00

Memo

10

10

180



Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod *M108436*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

*10.10.28**10*

10

10

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 ~~8~~ BE 10/11/02

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/11/02

T/O
LH

210

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 ~~8~~ 10-11-2

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115291,

0.00

Powder Coating

Memo

START TIME: 11:40
OVEN TEMPERATURE: 320°
FINISH TIME: 12:10

10

BR 10-11-3

230

Wing Walk as per dwg QSI005 4.4 Batch M115780

0.00



HandFinish

Memo

0.00

Hand Finishing

10

BR 10-11-4

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M 10/11/4

10

Ø

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:


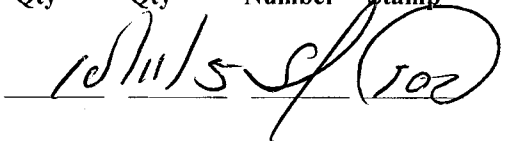



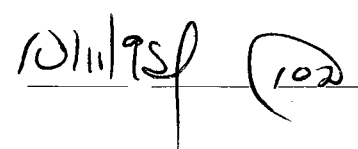
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  Packaging	Pick Kit Memo	0.00 0.00							
260  QC	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
270  Packaging	Packaging Memo	0.00 0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311 Location: _____								

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Page 7

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Reference:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/09 *[Signature]**MF*
10-11-9

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Monday, October 04, 2010 10:15:00 AM

Page 1

[illegible]**Required Date:** 11/10/2010

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fix route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1  End Plate		Manufactured	No			110	Each	72.0000	1	10		10.10.26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				72					
					60141			72					
D3219-1  Plate		Manufactured	No			110	Each	141.0000	2	20		10.10.26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				141					
					60859			27					
					61204			114					
D3272-1  Step		Manufactured	No			110	Each	15.0000	1	10		10.10.22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				15					
					862533			15					
					62134			15					

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Picklist Print

Monday, October 04, 2010 10:15:00 AM

Work Order ID: 62532

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

D3065-041 Manufactured No

180

Each

43.0000

1

10



Step Leg Assembly Hi



10.10.28

Location

Loc Qty

Loc Code

WA

43

60200

14

61216

29

180

Each

83.0000

2

20

D3066-1

Manufactured No



Spacer



10.10.28

Location

Loc Qty

Loc Code

WA

83

60194

35

61205

48

180

Each

72.0000

1

10

D3067-1

Manufactured No



End Plate



10.10.28

Location

Loc Qty

Loc Code

WA

72

60141

72

180

Each

1,699.000

16

160

MS20600-AD4W4

Purchased

No



Rivets



10.10.28

Location

Loc Qty

Loc Code

ST321

1699

113368

62

114181

11

114718

2

115573

624

115640

1000

45
175

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

AN3-35A Purchased No 250 Each 90.0000 2  20 10/11/5 sp

Bolt

Location	Loc Qty	Loc Code
ST353	90	
115108	40	
115457	50	

AN4-13A' Purchased No 250 Each 480.0000 8  80 10/11/5 sp

Bolt

Location	Loc Qty	Loc Code
ST358	480	
115159	480	

AN5-36A' Purchased No 250 Each 97.0000 2  20 10/11/5 sp

Bolt

Location	Loc Qty	Loc Code
ST341	97	
114292	5	
114941	92	

AN960JD10 NAS1149D0363J Purchased No 250 Each 8.0000 4  40 11/5622 10/11/5 sp (100)

Washer

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased No

250

Each

24.0000

16 160



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

AN960JD516 NAS1149D0563J Purchased No

250

Each

34.0000

4 40



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D2230-3 Manufactured No

250

Each

70.0000

4 40



Lug

Location

Loc Qty

Loc Code

ST476

70

55452

2

60846

68

D2618 Manufactured No

250

Each

83.0000

2 20



Bushing

Location

Loc Qty

Loc Code

ST019

81

60772

81

ST020

2

56892

1

57829

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Qty: 10.00

Required Qty: 10.00

D2856-400 *x2 @ 7.20m* *→ MESA* *5/10/10* Manufactured No

250 f

276.3760

0.6

6



Abraison Strip

Location

Loc Qty

Loc Code

ST403

276.3760421

56626

63.2560421

59920

213.12

D3235-1 Manufactured No

250 Each

57.0000

2

20



Mounting Lug

Location

Loc Qty

Loc Code

ST471

57

60490

17

60851

40

D3278-041 Manufactured No

250 Each

57.0000

1

10



Support Assembly

Location

Loc Qty

Loc Code

ST471

57

60201

17

61212

40

M21042L3 Purchased No

250 Each

1,720.000

2

20



Nut

Location

Loc Qty

Loc Code

ST300

1720

114523

49

114784

1671

W/O:		WORK ORDER CHANGES					
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Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

4,434.000

8

80



Nut

10/11/10 SP

Location

Loc Qty

Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

115589

1900

115621

1100

22
58

MS21042L5

Purchased

No

250

Each

899.0000

2

20



Nut

10/11/10 SP

100

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

873

115156

373

115594

500

20

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>QD</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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WORK IN PROGRESS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

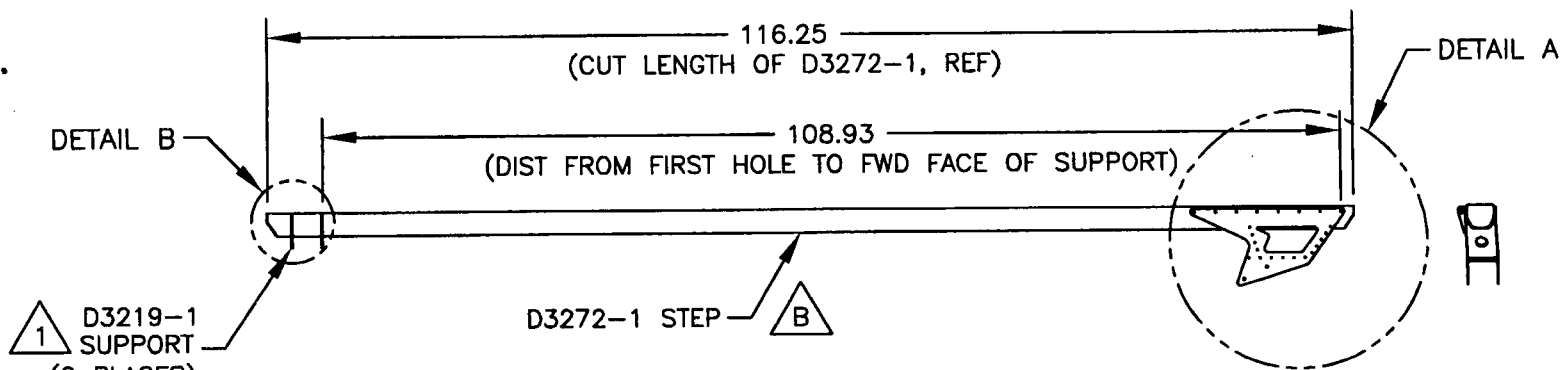
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



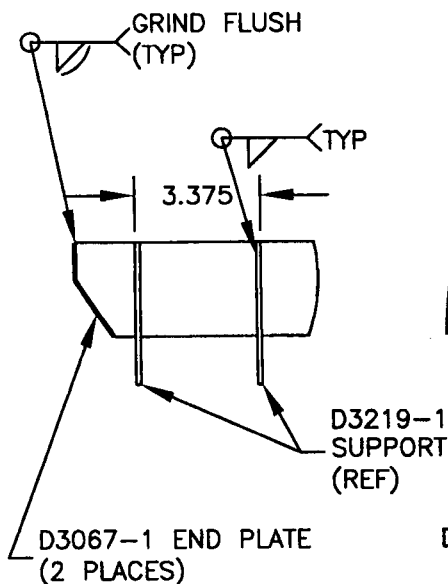
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	SHEET 2 OF 3
07.05.18	STEP ASSEMBLY, HI LONG	D3272	SCALE 1:20



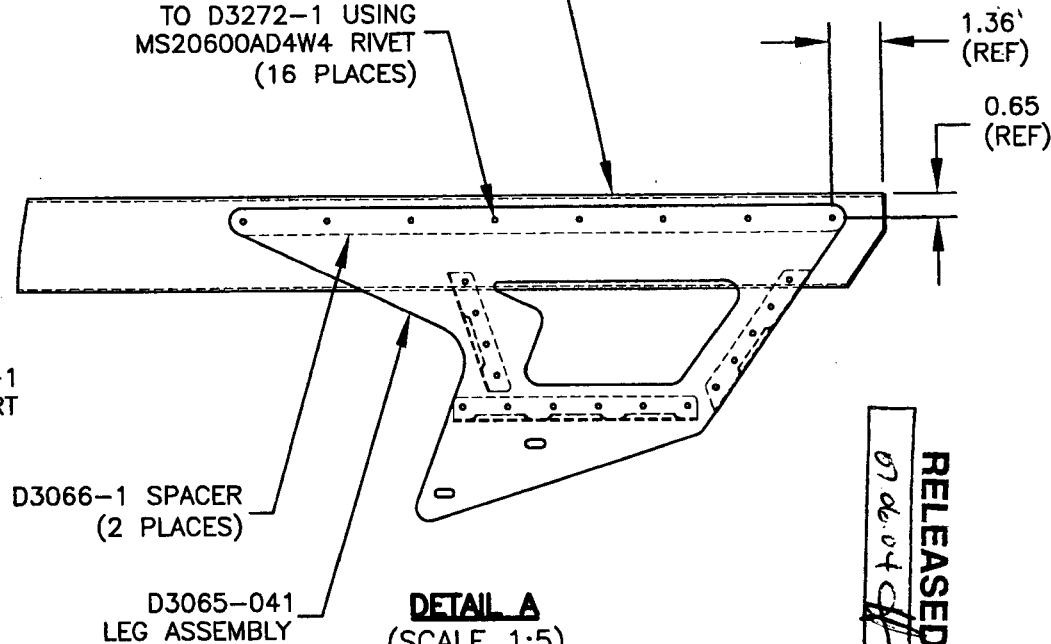
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

RIVET D3065-041
TO D3272-1 USING
MS20600AD4W4 RIVET
(16 PLACES)



DETAIL B
(SCALE 1:5)



DETAIL A
(SCALE 1:5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

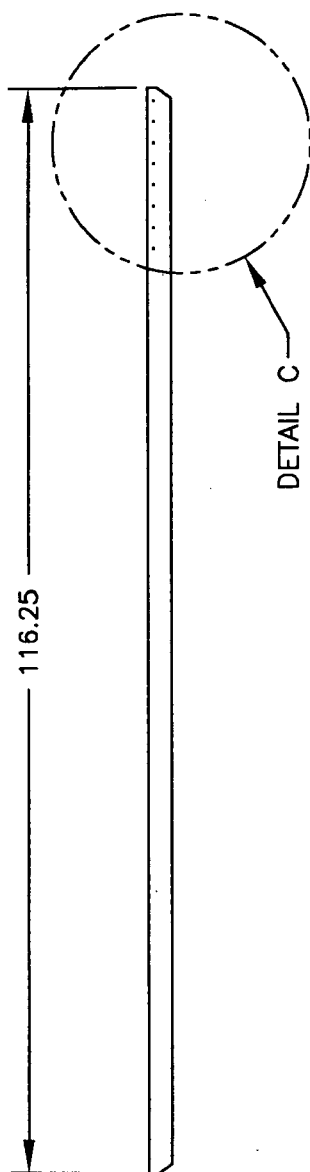
NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

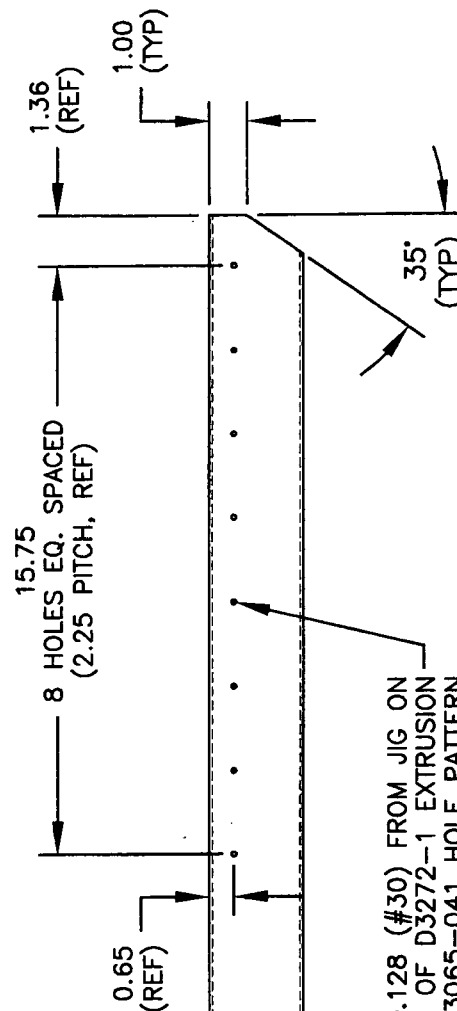
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.